

Claims

1. Method of producing a lining support plate in which:
 - a) a support plate pattern is prepared, whereby the support plate pattern has on one lateral face which corresponds to the face of the support plate facing a friction lining a plurality of recesses into each of which a pin is introduced in such a way that the pin partially projects out of the support plate pattern;
 - b) the support plate pattern and the portions of the pins projecting out of the support plate pattern are surrounded by a moulding compound,

the moulding compound is compressed and/or cured,

the support plate pattern is removed from the cured and/or compressed moulding compound in such a way that the pins with the portions projecting out of the support plate pattern remain in the moulding compound and a support plate casting cavity is formed into which the pins protrude;
 - c) a melt is poured into the support plate casting cavity, whereby the portions of the pins protruding into the support plate casting cavity are surrounded by the melt;
 - d) the melt is left to solidify in such a way that a cast iron lining support plate is formed;
and
 - e) the lining support plate is removed from the mould.
2. Method as claimed in Claim 1, wherein the pins introduced into the support plate pattern are constructed in such a way that the portions of the pins projecting out of the pattern have undercuts.

3. Method as claimed in any one of Claims 1 or 2, wherein the portions of the pins introduced into the recesses in the support plate pattern are contoured.

4. Method as claimed in any one of Claims 1 to 3, characterised in that when the melt solidifies it forms a cast iron with vermicular graphite.

5. Lining support plate with a cast metal base plate with a support surface to receive a friction lining material, wherein retaining elements project out of the support surface, characterised in that the base plate is made from cast iron, and that the retaining elements are pins which are cast into the base plate during production thereof in such a way that in each case a portion of the pins projects out of the support surface of the base plate.

6. Lining support plate as claimed in Claim 5, characterised in that the base plate is produced from cast iron with vermicular graphite.

7. Lining support plate as claimed in Claim 5 or 6, characterised in that the pins are constructed in such a way that the portions of the pins projecting out of the base plate have undercuts.

8. Lining support plate as claimed in any one of Claims 5 to 7, characterised in that a portion of the pins cast into the base plate during production thereof is contoured.

9. Method of producing a friction lining, in which a lining support plate is produced according to a method as claimed in any one of Claims 1 to 4, and a friction lining material with an organic binder is pressed onto the lateral surface of the lining support plate having the pins.

10. Friction lining with a lining support plate as claimed in any one of Claims 5 to 8 and a friction lining material, wherein a friction lining with an organic binder is pressed onto the support surface.